02933-2

R 1 6 9 1 6 6

109166

Page 1

November-12-13	3:19:46 PM	D 1 0	01	i i				••			******		
Item ID:	02933-2			Accept	*N900	<u> </u>	1100)* ፡	Setup	Start	*NI	21*	
Revision ID:	•			•	14.707	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		•		Stor	1 11	·	
Item Name: 2	06 Saddle Righ	nt								Stop	*N:	S2 *	
Start Date: 1	1/12/13	Start Qty: 10.00	*10*	•	Cust Item	ID:							1
Required Date: 1	1/26/13	Req'd Qty: 10.00	*10*	:	Customer	:							:
Reference:	 a	if.						_	_	64 - 4			1
Approvals:	Process Plan	: MCJ	Date: /3-//-	7 Tooling:]	Date:		ļ	Run	Start	*N	R1*	And a
1.67	QC:		Date:	SPC (Y/N):		Date:				Stop	*N	R2*	
Sequence ID/ Work Center ID		Operation Description	•	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revis	ion Nbr		!	-							i.	— . ;
D2933	Rev (
100				0.00			1	ή/ n					
1100		HAAS CNC VERTICAL	MACHINING #1	1				022T	-	3-	- () -	25 (40
HAĄS I		Memo		0.00			ď	9.89					
HAAS CNC vertical n	machine #1	number are properties as possible and properties as possible as possible and properties are properties as possible and properties are properties as possible are properties	programmed correctly.2	ber 1-Inspect part number -Machine Step No 1 of Fo d Dimension Sheet 3-Mac	lio and visually								
				•								7 .	18
110	•		•	0.00				DAS					
110		CONVENTIONAL MIL	LING MACHINE		•			1 35 P	T	13	.11.	-25 6	10
Mill Conv		Memo		0.00		·							
Conventional Milling	Machine	Machine Ke	yway and inspect per att	ached dimension sheet				."		•	idelia.		
										1			4 L
120		QC1- Inspect dimension	s to dimension sheet	0.00				D4.					
120 QC Quality Control		Memo		0.00				03 27 DAV	Γ	(3-	11-2	5 (x1	9

DQA:			Date:										TRAGG
OA Classili			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / U	PDATE	Vork Order u	ndata only	AEROSPACE
QA Closed:			Date:							· · · · · · · · · · · · · · · · · · ·	voik Order d	puate only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	!
	-					Rework	1 1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	١o.					Scrap			Machining	Small Fab	Pro	od. Eng. Coor.	Quality
	•					Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	١o.				•	Suspected Unapproved			Large Fab	Composite		Supplier	7 7
	•									_			
Root					Desci	ription of work order update	ı	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design												1	
Doc/Data			_						ļ				
Equip/Tooling											ļ		
Handling/Pre											1		
Material													
Operator	or			:	、								
Offset/Setup						£							
Process													
Supplier													
Training													
Transport													
Unapproved										. =			
							FA	ULT CA	TEGORY				
Landi	ng (Sear			_	General	_	•		_	_	_	_
		Bending				Bend		•	Program		Outside Dir	<u> </u>	Pressure/Forced
	Centre Not Concentric BOM/Route				4 ·		Grain			Over/Unde	_	Set-up	
	<u> </u>	Cracks				Broken/Damage/Defect	L	Hardwa	are		Part Incorre	eci	Temperature/Cure
		Crimp/Kink/Ripple/Wave Burrs				Inspection Incomplete/Unqualified		nqualified	Part Lost/N		Weld		
	Cuffs Contamination		-	4	tions Incomplete/	<u>-</u>	Part Moved	L	Wrong Stock Pulled				
	_	Crushing			L	Countersink		Misali	gned/off center	Ĺ	Positioned	_	_
	L	Heat Trea	at		L	Cut Too Short	<u></u>	Mislab	eled	L	Power Loss	/Surge	Other
	$ldsymbol{ld}}}}}}}$	Inspection	n Strip in	Tube	L	Drawing		Misrea					
		Marks/Ch	natter			Drill Holes		Off-set				****	
		Turning S	equence			Finish		Out of	Calibration				
	Wave/Twist in Tube			Fit/Function		Out of Sequence							

	Work	Order	ID	109166
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109166

Page 2

November-12-13 3:19:46 PM Item ID: D2933-2 Accept *N900040100* Setup Start Revision ID: Stop Item Name: 206 Saddle Right *10* **Start Oty: 10.00** Start Date: 11/12/13 **Cust Item ID:** Required Date: 11/26/13 Req'd Qty: 10.00 *10* **Customer:** Reference: Run Process Plan: _____ Date: ____ Tooling: Approvals: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Number Stamp Work Center ID Qty Description **Run Hours** Code **Qty** and 13/11/25 QC8- Inspect parts - second check 0.00 10 *120* 0.00 Memo Quality Control Chemical Conversion Coat per QSI005 4.1 0.00 10 & CF 13-11-25 *1/10* 0.00 HandFinish Memo Hand Finishing White Gloss(Ref: 4.3.5.1), per QS1005 4.3-Alum 0.00 150 . 10 6/3/11-26 *150* Powdercoat Memo Powder Coating

DQA:			Date:						_				TRAGG
			ъ.			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	147	- O	data anlı.	AEROSPACE
QA Closed:			Date:				_			VV	ork Order up	idate only	
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
Work Orac	- • •				-	Rework			Skid-tube Crosstube	Г		Water Jet	Engineering
Part N	۱o.					Scrap			Machining Small Fab	_	Pro	d. Eng. Coor.	Quality
	•				_	Use-as-is		Therr	noforming Finishing		Rec/Sto	e/Packaging	Other
NCR I	۱o. ₋					Suspected Unapproved			Large Fab Composite			Supplier	
Root					Desci	ription of work order update	l	nitial	Action		Sign &		-
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data	Ш										,		
Equip/Tooling													
Handling/Pre													
Material	Щ												
Operator	Ш					_							
Offset/Setup	Щ												
Process	Ш						l						
Supplier												:	
Training	$ldsymbol{ld}}}}}}$:
Transport													
Unapproved		_											
							FA	ULT CA	TEGORY				
Landi	ng (1				General		1	_	_	1		¬
		Bending			-	Bend	<u> </u>	1	Program	-	Outside Dim	 	Pressure/Forced
		Centre No	ot Concer	ntric	\vdash	BOM/Route	L.	Grain		\vdash	Over/Under	—	Set-up
		Cracks			-	Broken/Damage/Defect	L	Hardwa		\vdash	Part Incorre	ļ -	Temperature/Cure
	<u> </u>	Crimp/Kir	nk/Ripple	/Wave	\vdash	Burrs	<u> </u>	1 .	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	ssing	Weld
	\vdash	Cuffs			<u> </u>	Contamination	<u></u>	4	tions Incomplete/Unclear	L	Part Moved	L	Wrong Stock Pulled
	<u> </u>	Crushing			<u> </u>	Countersink	-	4	gned/off center	_	Positioned V	_	¬₋.
		Heat Trea			<u> </u>	Cut Too Short	<u></u>	Mislab			Power Loss/	Surge	Other
	<u></u>	Inspectio		Tube		Drawing	_	Misrea					
	<u></u>	Marks/Ch				Drill Holes	Off-set						
ĺ	Turning Sequence Finish			Out of Calibration									
	Wave/Twist in Tube			oe .		Fit/Function	Out of Sequence						

Work Ord				*109	166*							Page
Item ID: Revision ID: Item Name:	D2933-2 206 Saddle I	Right		Accept	*N900	040	100)*	Setup 5	Start Stop	171	S1* S2*
Start Date: Required Date: Reference:	11/12/13 11/26/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item II Customer:	D:						
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):		ite:				Start Stop	" 1/1	R1* R2*
Sequence ID/ Work Center II 160 *160*	D	Operation Description QC3- Inspect Part Finish		Set Up/ Run Hours AS 0.00 27	1	Tool#	Plan Code	Accep Qty	t Rejec Qty	ct	Reject Number	Insp. Stamp
QC Ouality Control		Memo		0.00	1104/							

Identify as per dwg & Stock Location: 51437

170 Packaging

Packaging

Memo

0.00

10× DAS 13-11-27 9-89

QC21- Final Inspection - Work Order Release

0.00

1 AN

Memo

Quality Control

0.00

Page 3

DQA:			Date:										
						WORK ORDER NON-CONFORMANCE / UPDATE							
QA Closed:			Date:					_		W	ork Order up	date only	<u> </u>
Work Orde	or.					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
Work Orac	- ' ' .					Rework			Skid-tube Crosstube		1	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
	•					Use-as-is			moforming Finishing		1	e/Packaging	Other
NCR 1	۱o.					Suspected Unapproved			Large Fab Composite]	Supplier	
Post			1		Docc	ription of work order update	Н	Initial	Action		Sign &		
Root Cause		Date	Step	Qty	Desci	or non-conformance	l	iiiiliai iief Eng			Date	Verification	QC Inspector
Design		Date	Step	Qty		or non-comormance	CII	ilei Liig	Description		Date	Vermeation	QC HISPECTOI
Doc/Data													
Equip/Tooling							1						
Handling/Pre									 				
Material													
Operator													
Offset/Setup													
Process													•
Supplier													
Training							l						
Transport						· ,							
Unapproved						<u> </u>							
							FA	ULT CA	TEGORY				
Landi	ng (Gear			_	General		,		_	-		_
	L	Bending			L	Bend		4	Program	<u></u>	Outside Dim	—	Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric	<u> </u>	BOM/Route		Grain		L	Over/Under		Set-up
	<u> </u>	Cracks			<u> </u>	Broken/Dámage/Defect	<u> </u>	Hardwa		_	Part Incorred	⊢	Temperature/Cure
	<u> </u>	Crimp/Kir	nk/Ripple,	/Wave		Burrs	<u>_</u>	4 '	tion Incomplete/Unqualified	_	Part Lost/Mi	ssing	Weld
	<u> </u>	Cuffs				Contamination	<u> </u>	-4	tions Incomplete/Unclear	_	Part Moved		Wrong Stock Pulled
	_	Crushing				Countersink	<u> </u>	4	gned/off center	L	Positioned V		\neg .
	<u> </u>	Heat Trea			<u> </u>	Cut Too Short	<u> </u>	Mislab			Power Loss/	Surge	Other
	_	Inspection	-	Tube	\vdash	Drawing	<u> </u>	Misrea					
	Marks/Chatter Drill Holes			Off-set									
	Turning Sequence Finish			-	-	Calibration							
1	Wave/Twist in Tube			1	Fit/Function	L	Out of	Sequence					

Picklist Print

November-12-13 3:19:50 PM

Work Order ID: 109166

109166

Parent Item:

D2933-2

D2933-2

Parent Item Name:

206 Saddle Right

Start Date: 11/12/13

Required Date: 11/26/13

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: B00.06.26New DWG rev (mpp 2069)EC IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	:
D6101-001		Manufactured	No			100	Each	44.0000	1 ()4	010				-
D6101-00	1			Æ	1672 (**) 2	E	13 -	11 -2	٥	_

Saddle Billet

Location	Loc Qty	Loc Code	
MAT042	44		
108097	26		
108272	16		
97239	2		

DQA:			Date:											
						WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE				AEROSPACE	
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	ır.					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
WOIK OIG	•					Rework	1		Skid-tube Crosstu	Water Jet	Engineering			
Part N	lo.					Scrap			Machining Small F	—	Pro	d. Eng. Coor.	Quality	
	•			·····		Use-as-is	1 1		noforming Finishi	_	+	re/Packaging	Other	
NCR N	lo.					Suspected Unapproved	1		Large Fab Compos			Supplier		
Root					Desci	ription of work order update	1	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng			Date	Verification	QC Inspector	
Design		i					l .		•					
Doc/Data														
Equip/Tooling	Щ													
Handling/Pre	\dashv													
Material	\dashv													
Operator				'			ļ							
Offset/Setup	\dashv						Ì							
Process			ŀ	 										
Supplier							1							
Training Transport														
Unapproved	!				ļ									
опарріотец				L	l		FAI	ULT CA	TEGORY		I	<u> </u>	<u></u>	
Landi	ng (Gear	·			General								
	$\overline{}$	Bending				Bend		 Folio/F	Program		Outside Dim	ensions	Pressure/Forced	
		Centre No	ot Concer	ntric		BOM/Route		Grain	_		Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí	Temperature/Cure	
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/Mi	issing	Weld	
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled	
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong		
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other	
		Inspection	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Ch	natter			Drill Holes		Off-set						
Turning Sequence Finish			Out of Calibration											
Wave/Twist in Tube Fit/Function			L	Out of	Sequence									

DART AEROSPACE LTD	Work Order:	109/66
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

		-		Red	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		.108	. 107	JO6	109		
В	0.100	0.140	•	.106	,106	106	.106		
С	0.100	0.140		-123	1122	.125	.125		
D	0.210	0.230		.224	.224	-225	.224		
E	1.245	1.255		1.250	1,250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		*
G	2.495	2.505		2.500	2.500	2.100	2.500		
Н	0.510	0.515		.50	.510	.510	.510		
ı	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		,260	, 260	260	.260		
L	0.312	0.317		314	314	:314	-314		
M	0.235	0.240		237	.238	236	.233		
N	0.100	0.140		1122	.123	.123	.123		
0	0.540	0.560		.544	544	544	744		
Р	0.490	0.510		,493	,493	,493	.500		
Q	3.715	3.725		3.770.	3.720	3.720	3.720		
R	2.470	2.510		2.490	.2.490	2.490	2.490		
S	0.240	0.270		.25 1	249	.252	.251		
Т	0.100	0.180		.140	.140	.140	,140		
U	1.625	1.635		1.630	1.630	1-630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.317	317	.317 -	1.367		
X	1.125	1.145		1.136	1.139	1.135	1.135		
Υ	1.565	1.585	DT8695 A/B	1.576	1.579	1.575	1.575		•
Z	0.178	0.198		880.	.086	.088	.088		
AA					***************************************				
AB									
AC									
AD									
AE					,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,				
AF							-		
AG									············
АН									
	Acc	ept/Reje	ct						

	<i>1</i> 4 c	_	
Measured by:	10 TT		Audited by Audited by
Date:	18913-11-25		Date: 13/11/25

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	21
С	07.03.21	Revised per drawing revision C	KJ/JLM	411

DQA:			Date:	Date:									TRACT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only	
Work Orde	r:					DISPOSITION			AGAINST				
Work Orde	-				_	Rework S			Skid-tube Crosstube	Г	1	Water Jet	Engineering
Part N	o.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
Tarcino.				Use-as-is	1		noforming Finishing	\vdash	4	re/Packaging	Other		
NCR No.				Suspected Unapproved]		Large Fab Composite	e Supplier					
Post]		Dosc	l ription of work order update		nitial	Action		Sign &		
Root Cause	Date Step Qty		Desci	or non-conformance	ı	iiiliai iief Eng			Date	Verification	QC Inspector		
Design	\dashv	Date	эсер	Qty		of non-comormance	Cil	ilei Liig	Description		Dute	Vermeation	Qe mspector
Doc/Data	\dashv												
Equip/Tooling	\dashv						1						
Handling/Pre	\dashv												
Material	ヿ												
Operator													
Offset/Setup													
Process													
Supplier							Ì						
Training									÷				
Transport													
Unapproved											<u> </u>		
							FA	ULT CA	TEGORY			-	
Landi	ng G	Gear				General		_		_	-	_	_
		Bending				Bend		Folio/f	Program	L	Outside Dim		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		L	Over/Under	<u> </u>	Set-up
		Cracks				Broken/Damage/Defect	<u></u>	Hardwa			Part Incorre	├	Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave	_	Burrs	_	-l '	ion Incomplete/Unqualified	<u> </u>	Part Lost/M	issing	Weld
		Cuffs				Contamination	_	4	tions Incomplete/Unclear	\vdash	Part Moved		Wrong Stock Pulled
	Crushing				Countersink	\vdash	-	gned/off center	\vdash	Positioned V	_	٦٠	
	Heat Treat			<u> </u>	Cut Too Short	\vdash	Mislab		L	Power Loss/	Surge	Other	
	Inspection Strip in Tube			<u> </u>	Drawing	\vdash	Misrea						
	Marks/Chatter				\vdash	Drill Holes	\vdash	Off-set					
	_	Turning S			<u> </u>	Finish	—	┥	Calibration				
	Wave/Twist in Tube Fit/Fun				Fit/Function	L	Out of	Sequence					

[・]H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	109166
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Re	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	5 X	6 Z	78	8 #	Ву	Date
Α	0.100	0.140		-108	<i>-</i> ((\	10%	109		
В	0.100	0.140		.107	106	106	OC		
С	0.100	0.140		122	.106	.106	.122		
D	0.210	0.230		.223	.222	.223	.223		
Е	1.245	1.255		1.250	1.250	1,250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
Н	0.510	0.515		.590	1.50	.510	1710		
1	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2-500	2.500	2.500	2.500		
K	0.257	0.262		-260	. 260	,260	.240		
L	0.312	0.317		.314	.314	.314	314		
M	0.235	0.240		1237	.236	.237	,278		
N	0.100	0.140		,122	1,122	.720	1122		
0	0.540	0.560		.545	.544	.547	1544		
Р	0.490	0.510		.494	.491	.495	.494		
Q	3.715	3.725		3.720	3.720	3.725	3.720		·
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.252	.254	.252	.253		
Т	0.100	0.180		.140	.140'	.140	./40		
U	1.625	1.635	,	1.670	1.630	1.630	1.630	·	
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.317	317	.317	317		
Х	1.125	1.145		1.135	1.135	1.135	1.135		
Υ	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		.088	-088	-286	. ७४६		
AA									
AB									
AC									
AD									
AE									
AF									
AG				_					
ΑH									
	Acc	ept/Reje	ct						

	Da			
Measured by:	000 8		Audited by ,	
Date:	13-11-25	1	Date: 13/11/25	

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	21
С	07.03.21	Revised per drawing revision C	KJ/JLM OK	

DQA:		Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / U					AEROSPACE
QA Closed:			Date:					,		W	ork Order up	date only		
Work Orde	. r.				:	DISPOSITION				PROCESS				
Work Order.				Rework		•	Skid-tube	Crosstube	Water Jet Engin			Engineering		
Part No.			•	Scrap		Machining Small Fab			Prod. Eng. Coor.			Quality		
	•					Use-as-is			noforming	Finishing	4	e/Packaging	1	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite	1	Supplier		Н
							•				_	<u>, </u>		
Root					Desc	ription of work order update	I	Initial	Act	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification		QC Inspector
Design			ļ	<u> </u>										
Doc/Data														
Equip/Tooling														
Handling/Pre	Ш													
Material													1	
Operator									<u> </u>					
Offset/Setup														
Process .									ļ				-	
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Training	Ш													
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Unapproved													_L	
							FA	ULT CA	TEGORY					
Landi		ī				General	_	1			7			/m 1
		Bending			\vdash	Bend	<u></u>	- '	Program	ļ_	Outside Dim	-	_	ressure/Forced
		Centre No	ot Concei	ntric	 	BOM/Route	\vdash	Grain		<u> </u> _	Over/Under	1-	_	et-up
		Cracks			<u> </u>	Broken/Damage/Defect	\vdash	Hardwa			Part Incorre		_	emperature/Cure
 		Crimp/Kii	nk/Ripple	/Wave	_	Burrs	\vdash	- i	ion Incomplete/U	_	Part Lost/Mi	ssing		Veld
	Cuffs			Contamination	_	-4	tions Incomplete/I	Unclear	Part Moved	. <i>.</i>	\v	Vrong Stock Pulled		
	Crushing		Countersink	\vdash	-1	gned/off center		Positioned V		\neg_{\sim}	Nelson			
	Heat Treat			<u> </u>	Cut Too Short	\vdash	Mislabe		<u>L.</u>	Power Loss/	ourge [IO	ther	
	Inspection Strip in Tube			Drawing	L	Misrea				···		**		
ļ	<u> </u>	Marks/Chatter Drill Holes				╡	\vdash	Off-set						
		Turning S	-			Finish	\vdash	4	Calibration			,		
1	1	Wave/Twist in Tube Fit/Function						Out of	Sequence					

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DART AEROSPACE LTD	Work Order:	109/66
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

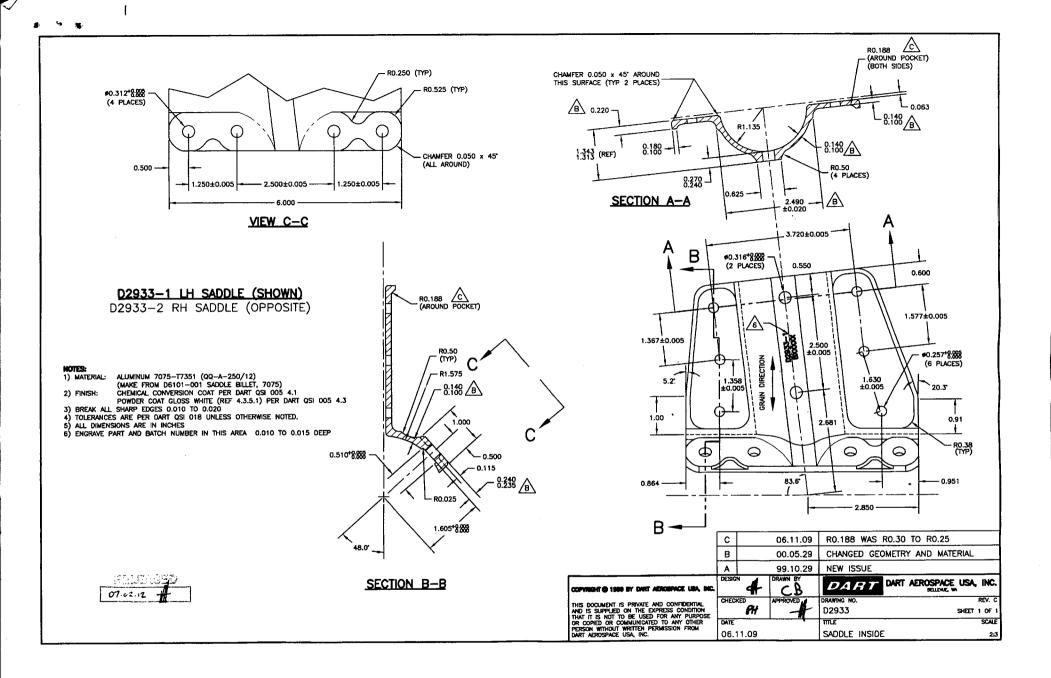
<u> </u>				Red	corded Actu	ual Dimensio	ons		
Dim	Min	Max	Go/No Go Gauge	91	107	3	4	Ву	Date
Α	0.100	0.140		10%	.108				
В	0.100	0.140		. (09	.129				
С	0.100	0.140		-125	1.124				
D	0.210	0.230		.222	. 223'				
E	1.245	1.255		1.290	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
Н	0.510	0.515		.50	.410				
1	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.00	2.500				
K	0.257	0.262		.260	.260		,		
L	0.312	0.317		.360	314				
М	0.235	0.240		236	.237	1.44 8			
N	0.100	0.140		.122	-122				
0	0.540	0.560		.547	,546				
Р	0.490	0.510		.496	494	•			
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.490	2.490				•
S	0.240	0.270		.252	1.452				*
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.620	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.317	.317				
X	1.125	1.145		1.134	1.134				
Υ	1.565	1.585	DT8695 A/B	1.574	1.573				
Z	0.178	0.198		.088	-088				
AA							<i>,</i>		
AB									
AC									
AD									
AE									
AF				-					
AG									
AH									
	Acc	ept/Reje	ct						

/ 340	
Measured by:	Audited by
Date: 7.7 13 -11-25	Date: 13/1/25

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	21
С	07.03.21	Revised per drawing revision C	KJ/JLM C	

DQA:			Date:											
						WORK ORDER NON-	-CC	ONFOR	RMANCE / UPD	ATE			AEROSPACE	
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	er:					DISPOSITION AGAINST			AGAINST DE	T DEPARTMENT/PROCESS				
Work Orac	•					Rework	ıl		Skid-tube C	Crosstube	1	Water Jet	Engineering	
Part N	lo.					Scrap			—	Small Fab	Proc	d. Eng. Coor.	Quality	
	•		-			Use-as-is			noforming	Finishing		e/Packaging	Other	
NCR N	lo.					Suspected Unapproved			~ >	omposite	1	Supplier	1 1	
	•						•			•	•	· · · · ·		
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descripti	ion	Date	Verification	QC Inspector	
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Doc/Data														
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Landi		1				General Bend		lralia/r	Program		Outside Dim	onsions [Pressure/Forced	
	-	Bending Centre No	ot Concor	atric	-	BOM/Route	\vdash	Grain	Tograffi	-	Over/Under		Set-up	
		Cracks	ot concei	ILTIC	\vdash	Broken/Damage/Defect	\vdash	Hardwa	ıra	-	Part Incorred	h	Temperature/Cure	
		Crimp/Kii	nk/Rinnle	/\ M /ava	-	Burrs	\vdash	-i	ion Incomplete/Unqua	alified	Part Lost/Mi	-	Weld	
		Cuffs	IIV MIPPIE	, wave	\vdash	Contamination	\vdash	1 '	tions Incomplete/Uncl		Part Moved	-	Wrong Stock Pulled	
	\vdash	Crushing				Countersink	-	4	ned/off center	· •	Positioned V	∟ Vrong	J	
	Heat Treat			 	Cut Too Short		Mislabe	-		Power Loss/		Other		
Inspection Strip in Tube					Drawing	\vdash	Misrea		L	_	· _			
	Marks/Chatter					Drill Holes		Off-set			*******			
	Turning Sequence					Finish		Out of	Calibration					
	Wave/Twist in Tube					Fit/Function		Out of Sequence						

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109/64/15-11-12

DQA:	3	Date												T Q A G	
	WORK ORDER NON-CONFORMANCE / UPDATE												_		AEROSPACE
QA Closed: Date:						Work Order update only									
Work Order:						DISPOSITION	AGAINST DEPARTMENT/PROCESS								
						9	Child the Constitute C				Water Jet			l Cueineasine 🗔	
					Rework		Skid-tube Crosstube Machining Small Fab				Prod. Eng. Coor.			Engineering Quality	
Part No.				Scrap Use-as-is		Thermoforming Finishing				Rec/Store/Packaging			Other		
NCR No.						Suspected Unapproved		Large Fab Composite				Supplier			, отнет
New	110.	-	·								٠٠ بـــ				
Root					Desci	ription of work order update		nitial	Act	ion		Sign &			
Cause		Date	Step Qty or non-conformance			Chief I		g Description			Date Verificatio		n_	QC Inspector	
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Doc/Data														ļ	
Equip/Toolin	g 🗌	<u> </u>			,	· · · · · · · · · · · · · · · · · · ·	, ,	* .				į			
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Process	<u>_</u>	1									ı				
Supplier	<u> </u>	4 .	-			e e		**	,		-				
Training	<u> </u>	4						,] /						
Transport	\perp	1:				•	l					,			
Unapproved		<u></u>	<u> L</u>				<u></u>	<u>, , , , , , , , , , , , , , , , , , , </u>						_	
							FA	ULT CA	TEGORY					—	· · · · · · · · · · · · · · · · · · ·
Land	ling (Gear 1				General		Folio/Program				o		_	10
	-	Bending Contro Not Concentric			-	Bend BOM/Boute	-	4	rogram	1	\rightarrow	Outside Dimensions Over/Under tolerance		\vdash	Pressure/Forced Set-up
	┢	Centre Not Concentric				BOM/Route	-	Grain Hardware			_	Part Incorrect		H	Temperature/Cure
	Cracks Crimp/Kink/Ripple/Wave				 	Broken/Damage/Defect	-	-	on Incomplete/Unqualified		-	Part Lost/Missing		_	Weld
	Cuffs				-	Burrs Contamination	\vdash	- '		_	Part Moved			Wrong Stock Pulled	
	\vdash	Crushing				Countersink	\vdash	4	tions Incomplete/Unclear gned/off center			Positioned Wrong			Wrong Stock Fulled
		Heat Treat						Mislabeled				-			Other
	-	Inspection Strip in Tube				Drawing		Misread				. 5110. 2033/			1000
		Marks/Chatter				Drill Holes	-	4	Off-set						
İ	Turning Sequence					Finish	\vdash	Out of Calibration							
		Wave/Twist in Tube				Fit/Function Out of Sequence									